







Work Order ID 59155

Thursday, May 27, 2010 9:22:25 AM



Page 1

Item ID: D3909-1 Accept  Setup Start 
Revision ID:  Cust Item ID: Stop 
Item Name: Lug Plate, Fwd Crosstube
Start Date: 5/27/2010 Start Qty: 10.00 Required Date: 6/4/2010 Req'd Qty: 10.00 Customer:
Reference:

Approvals: Process Plan: *K* Date: 10-5-27 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3909	B								

100		0.00							
-----	--	------	--	--	--	--	--	--	--

 Waterjet Memo 0.00 B 10-5-28

FLOW CNC Waterjet Cut as per dwg D3909 
Prog Rev: *B* 
Dwg Rev: *B*
Deburr as required

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

 QC Memo 0.00 B 10-5-28

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3909-1

Accept



Setup Start



Revision ID:

Item Name: Lug Plate, Fwd Crosstube

Stop



Start Date: 5/27/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

S. Wolstz

0.00

Memo

(415)

150



Packaging

Packaging

Identify as per dwg & Stock Location: 95

0.00

0.00

Memo

10-5-31

(150) SP

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/06/01

10-6-01 (15)

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Picklist Print

Thursday, May 27, 2010 9:22:29 AM

Page 1

Work Order ID: 59155



Parent Item: D3909-1



Parent Item Name: Lug Plate, Fwd Crosstube

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC
per revPA3 DD verified by:EC
DD 10.04.20 verified by:EC
IPP RevB: as
IPP RevC: as per dwg revB

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M304S11GA		Purchased	No			100	sf	44.6800	0.195	2.052632	3,		
304/316 0.125 Sheet													



1310-5-08

Location

Loc Qty

Loc Code

MAT

44.68

114488

44.68

114488

⑤

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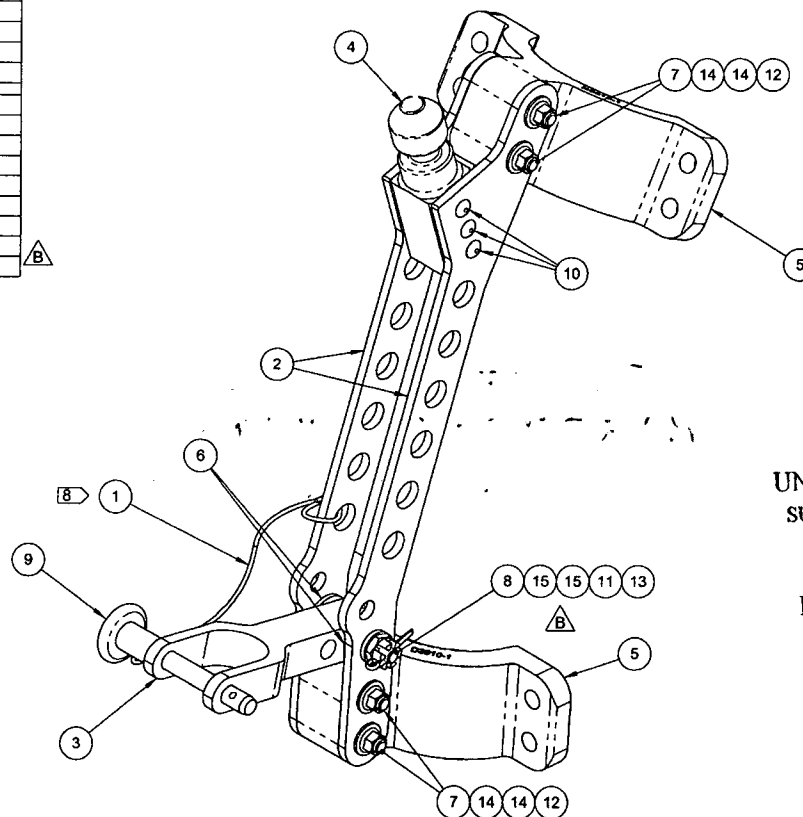
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20815-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER






D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.74 lbs
- 8) ATTACH TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59155
BS10-5-27

RELEASED
2010-04-07
mp

B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED: SECTION A-A & DIM Ø0.850 REMOVED. SIDE VIEW ADDED, DIM: 2.08 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220, R0.06 WAS R0.05. WEIGHT REVISED.		JPH	10.04.06
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3909 TITLE FWD X-TUBE LUG ASSY	REV. B	
DRAWN	JPH		SHEET 1 OF 5	
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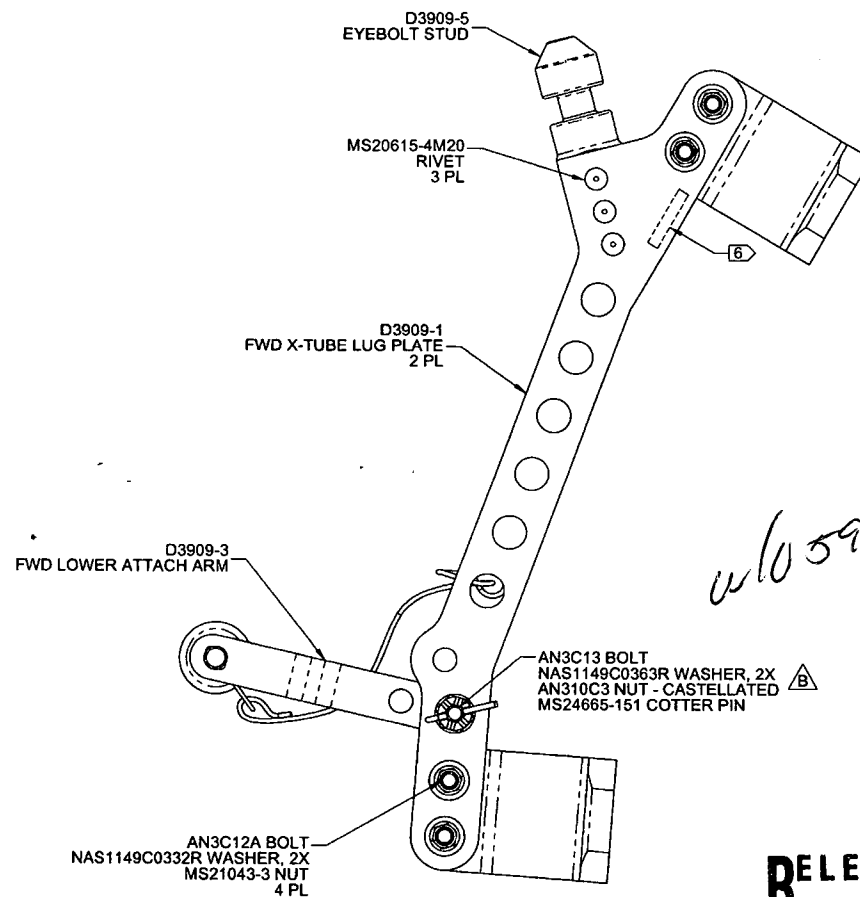
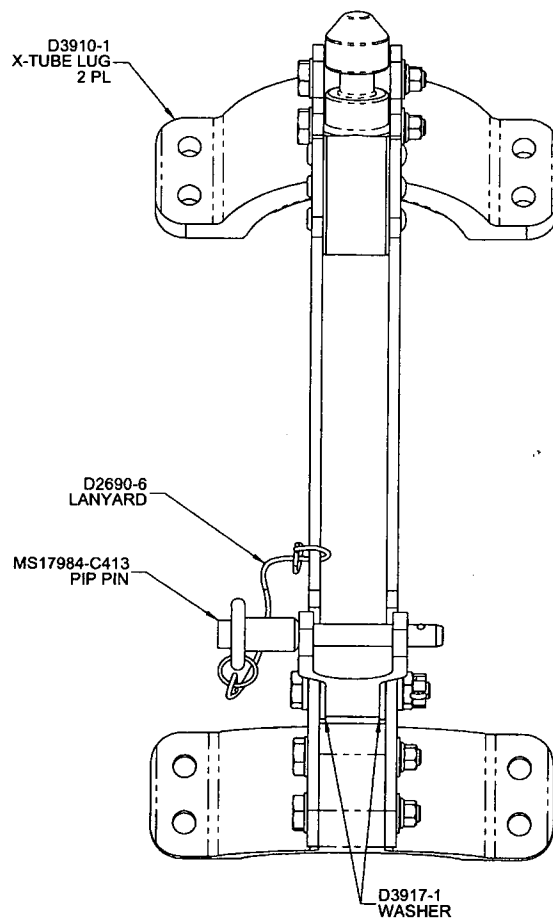
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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D3909-041 FWD X-TUBE LUG ASSY

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2010-04-07
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NTS
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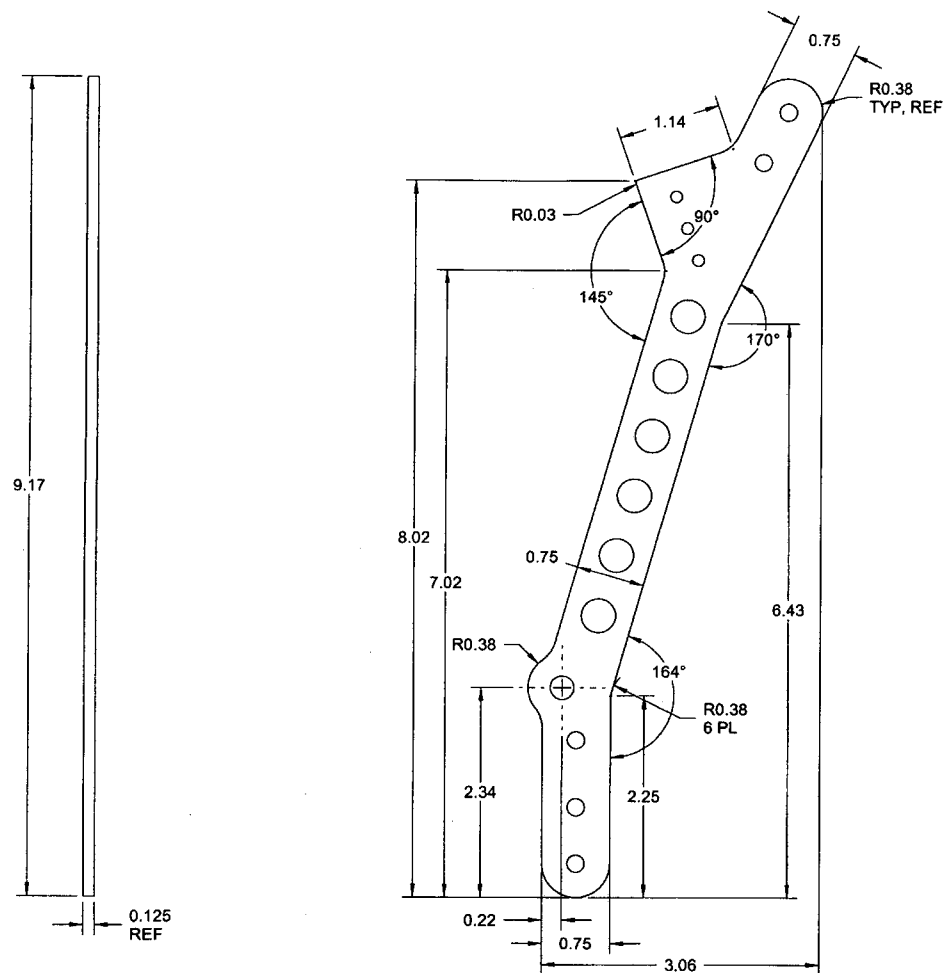
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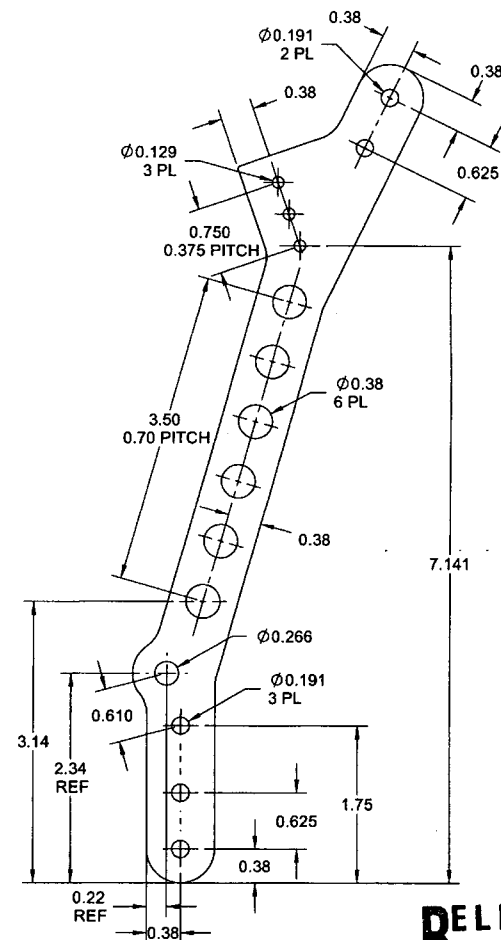
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D3909-1 FWD X-TUBE LUG PLATE



(SUPPLEMENTAL VIEW)

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

w/o 59155

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2010-04-07

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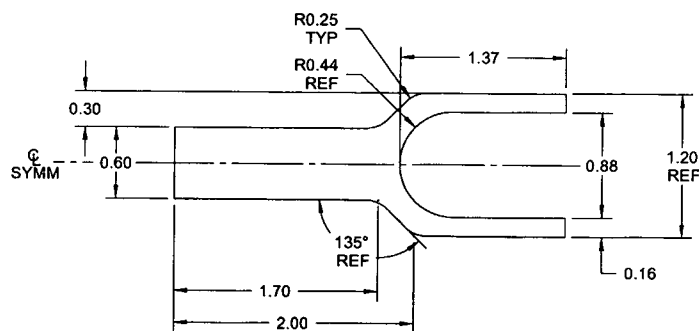
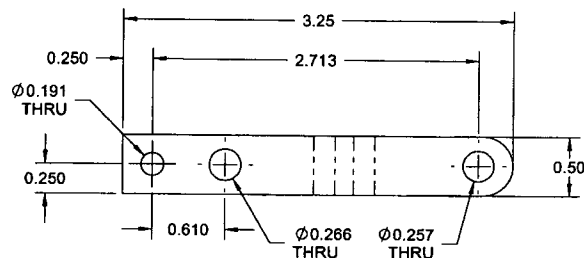
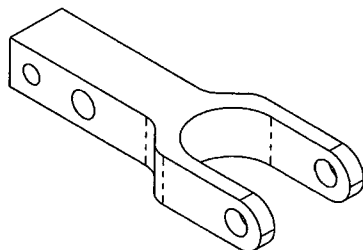
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NOTE: Date & initial all entries



D3909-3 FWD LOWER ATTACH ARM

u/b 59155

RELEASED
2010-04-07
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

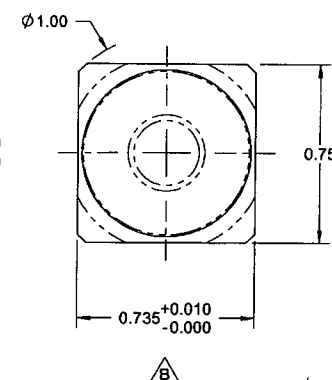
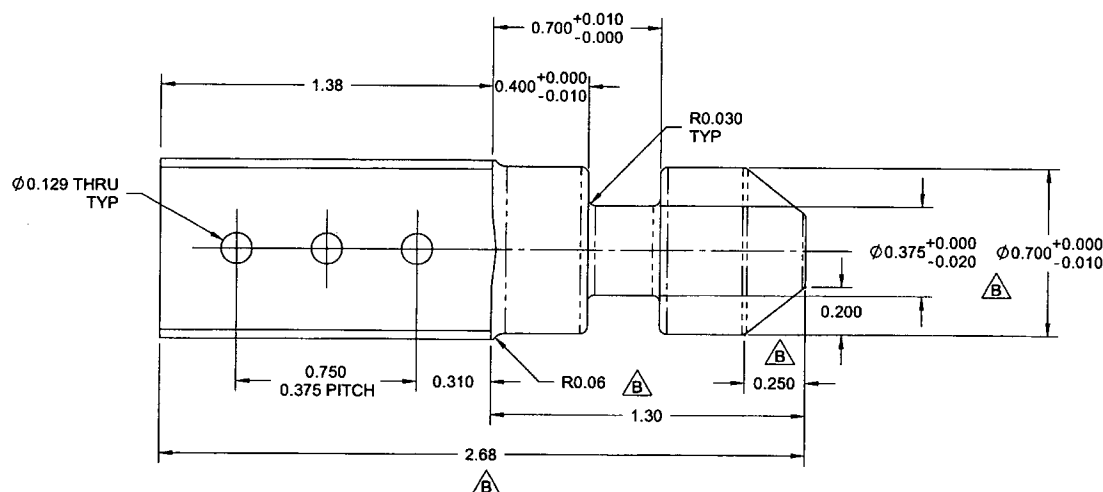
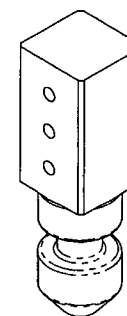
A

D

C

B

A







D3909-5 EYEBOLT STUD

w/059155

RELEASED
2010-04-07
WMP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3909	REV. B
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8 7 6 5 4 3 2 1

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